

Work Order ID 132316

Wednesday, May 06, 2015 3:18:20 PM

132316

Page 1

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Center
 Start Date: 5/6/2015 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 5/6/2015 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAY 06 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3536 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2- Debur if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAG
38
9-89
MAY 11 2015

Wednesday, May 06, 2015 3:18:20 PM

Page 2

ML5

Picklist Print

Wednesday, May 06, 2015 3:18:24 PM

Page 1

Work Order ID: 132316

132316

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket Center

Start Date: 5/6/2015

Required Date: 5/6/2015

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

356.2000

0.5956

17

MNEO60S 063

NEOPRENE SHEET 0.063

05/05/08

Location

Loc Qty

Loc Code

MAT052

356.2

M131990

356.2

130840

16.8

DART AEROSPACE LTD		Work Order:	132316
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	/		V: D-02	
16.35	+/-0.030	16.35	/			
10.90	+/-0.030	10.90	/			
5.45	+/-0.030	5.45	/			
6.00	+/-0.030	6.00	/			
6.75	+/-0.030	6.75	/			
12.75	+/-0.030	12.75	/			
1.89	+/-0.030	1.89	/			
0.30	+/-0.030	.305	/			
0.30	+/-0.030	.305	/			
Ø0.19	+0.005/-0.001	Ø.190	/			

DAS

Measured by:	DC	Audited by:	38	Prototype Approval:	N/A
Date:	15/05/08	Date:	9-89	Date:	N/A
			MAY 11 2015		

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

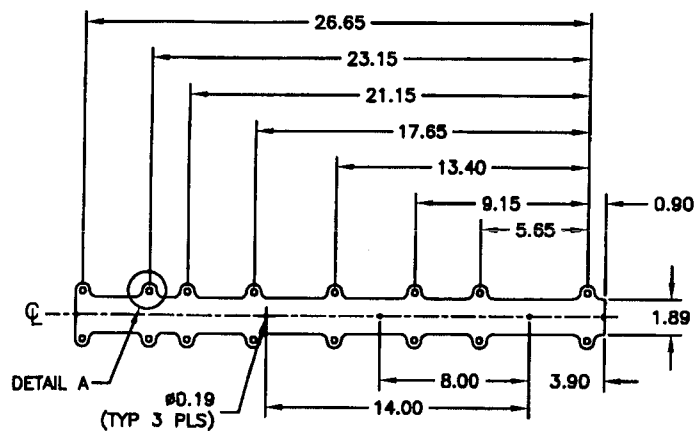


RELEASED
09.02.12-11

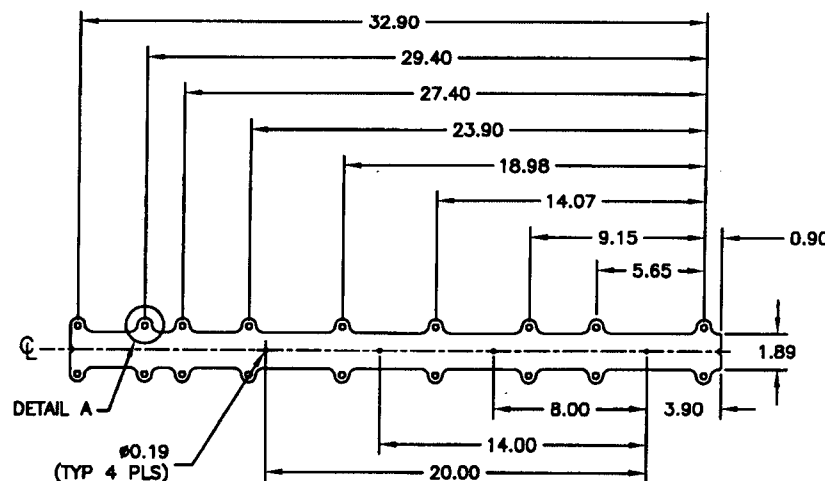
UNCLASSIFIED COPY
EXCLUDED FROM AUTOMATIC
DECLASSIFICATION
AUTHORITY
10-13-2316 MLC

MAY 06 2015

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25		TITLE GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE	SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

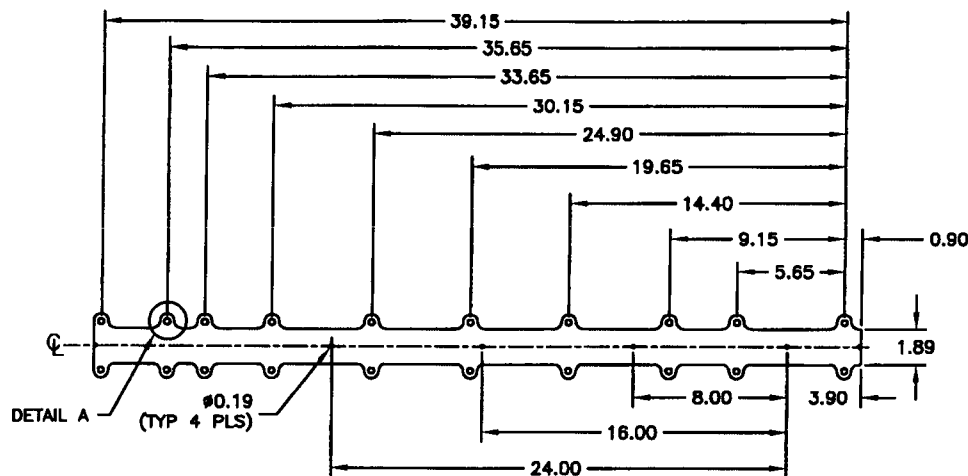
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

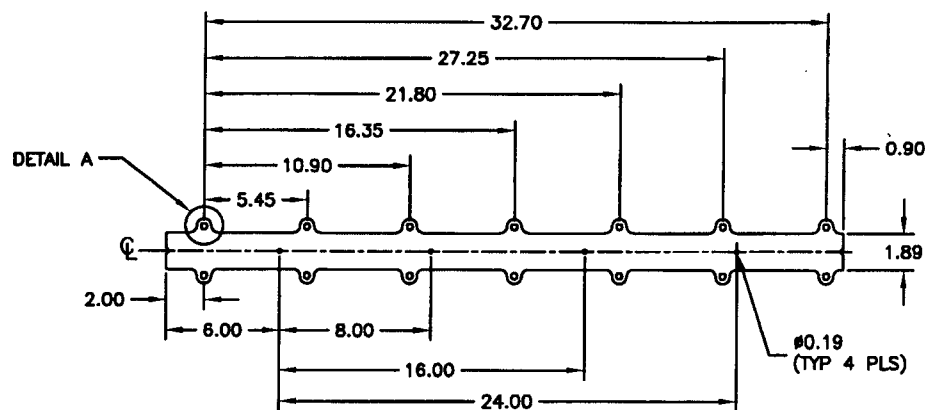
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	
CHECKED	PH	APPROVED	PH	DRAWING NO.	PORT HADLOCK, WA
DATE	06.10.25			D3536	REV. A
				TITLE	SHEET 2 OF 6
				GASKET	SCALE
					1:10

RELEASED
070212



D3536-15 GASKET



D3536-21 GASKET

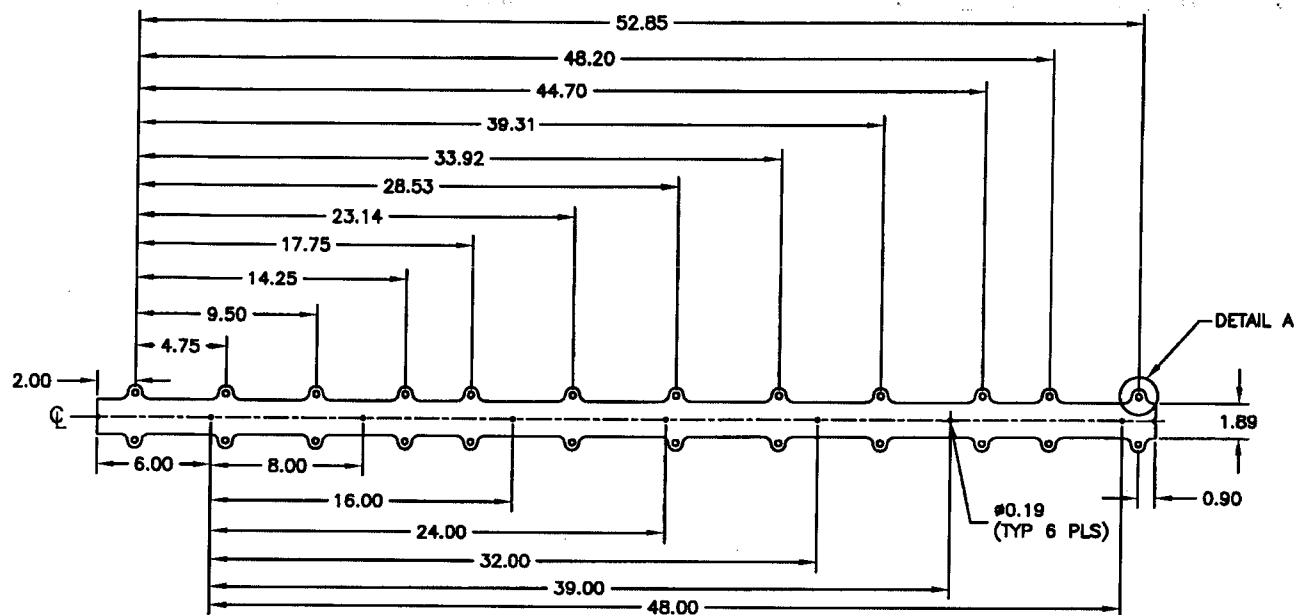
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

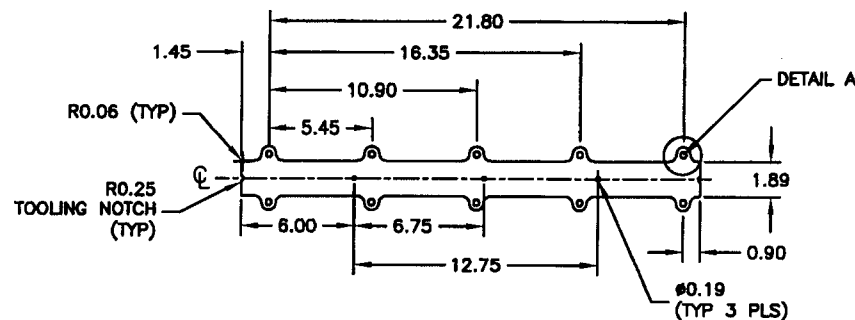
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
TITLE	GASKET	SHEET 3 OF 6	SCALE	1:10

RELEASED
070212



D3536-23 GASKET



D3536-25 GASKET

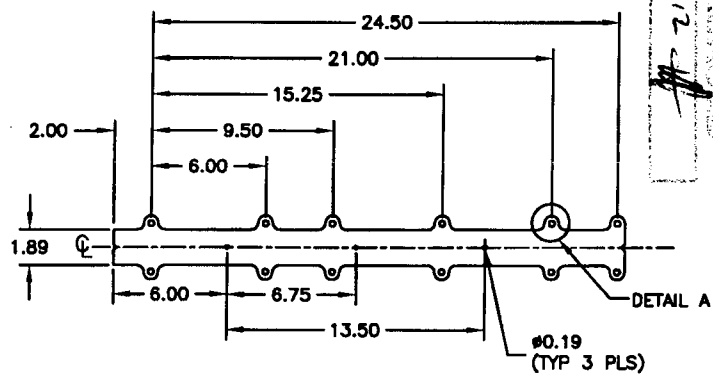
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

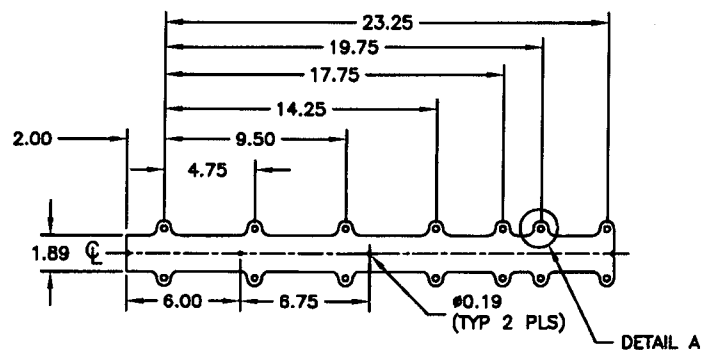


DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

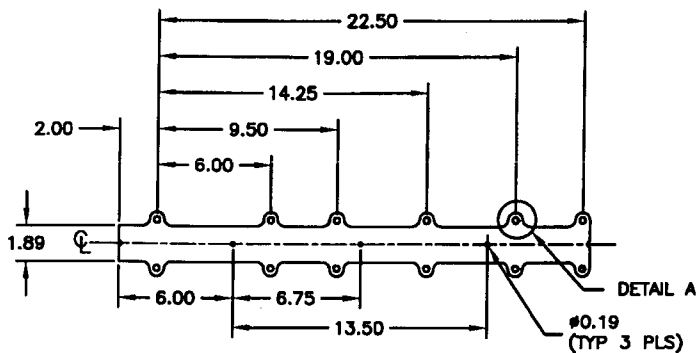
RELEASED
07.02.12



D3536-33 GASKET



D3536-35 GASKET



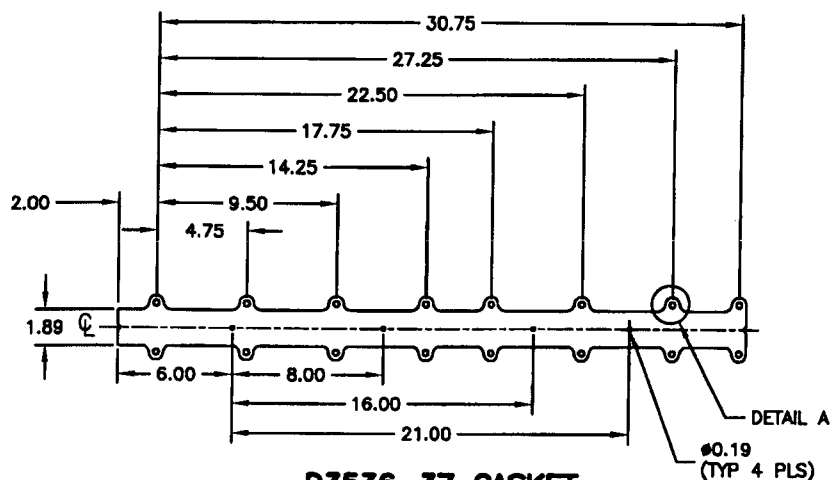
D3536-31 GASKET

NOTES

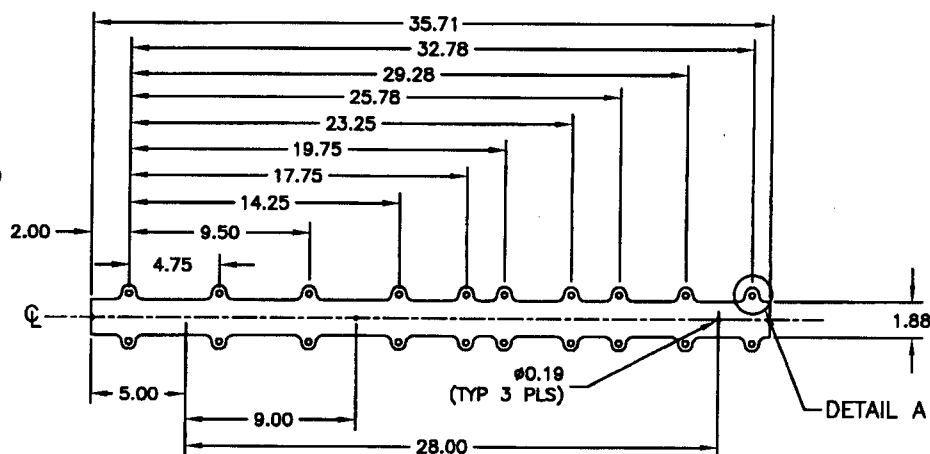
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 5 OF 6
				SCALE 1:10



D3536-37 GASKET



D3536-39 GASKET

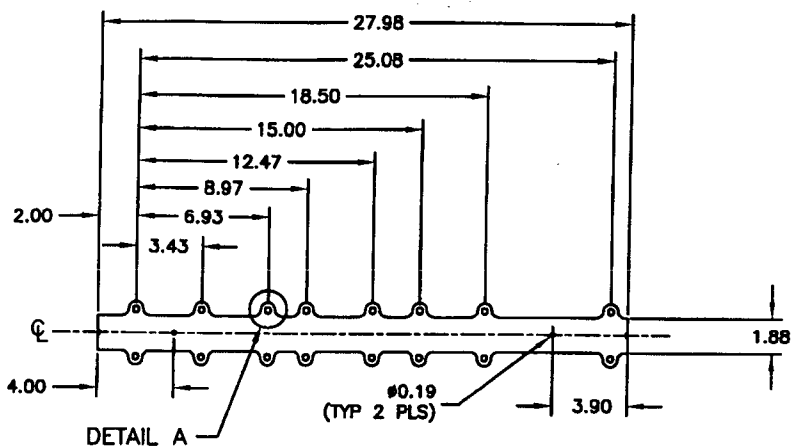
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AM	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 6 OF 6
				SCALE 1:10

07.02.12 *[Signature]*



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

